

slip 28/04

Dart Aerospace Ltd.

Date: Tuesday, 08/04/2008 4:54:53 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R/H STEP ASSY
Job Number : 38462	
Estimate Number : 13170	
P.O. Number :	Part Number : D3724042
This Issue : 08/04/2008 S.O. No. :	Drawing Number : D3724 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 38219	Material :
Written By :	Due Date : 25/04/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.4.09</u>	
Comment : Est Rev:A new issue 08-02-07 DD verified by: Est Rev:B ecn 1154p 08-03-13 DD verified by: Est Rev:C ecn 1158 08-03-19 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Qty Part # Description Batch:
1.25 D2622-120C Extrusion 36923

Check Material for any Dents or Defects

SAD 08/04/10 ①

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-2 as per dwg D3737

2-Cut D3738-2 as per dwg D3738

3-Deburr and bevel ends for welding

SAD 08/04/10 ①

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JD 08.04.13 1

4.0	D37331	GUSSET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GUSSET
batch 338468

JD 08.04.15 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:54:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

Pl 08.04.15 1
Pl 08.04.15 1

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pl 08.04.16 1

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pl 08.04.16 1

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pl 08.04.22

10.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

batch *B36520*

Pl 08.04.16 1

11.0 D37281 STEP BRACKET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PLATE

batch *B38223*

x3 ✓

ml

12.0 D37291 STEP BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE

batch *B38468*

x1

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37301

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B37843

x2

✓

B38600

x6

ml

14.0

D37411

ANGLE



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B38224

x4

✓

B38470

x4

ml

15.0

MS20470AD511

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

batch

M107100

✓

ml

16.0

MS20470AD516

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M107100

✓

ml

17.0

CR321354

Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Cherry Rivet

batch

M107100

08-04-22

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Apply Magnobond before installing rivets

A/R Magnobond 6398 Batch: M104723

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

GA ml 08/04/16

08-04-22 /
08-04-22 /

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:54:53 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Apply magnabond as per dwg D3724

A/R Magnabond 6398 Batch: M106695

6-Rivet brackets in place on step as per dwg D3724

7-Weld both end cap as per Dwg D3724

8-Grind end cap welds flush

Inspect for foreign object per QSI 024

Handwritten notes:
08.04.22 /
08.04.24 /
08.04.24 /
08.04.24 /

19.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten: 08/04/24 (X)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/04/24 (X)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: M-1 08/04/24 1338462

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M107550

Handwritten table:
S.114 13.58
#1 320.7 F
#2 --- F
#3 320.7 F
#4 --- F

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: M-1 08/04/24

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

Handwritten: M107385

Handwritten: M-1 08/04/24

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/04/24 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 4:54:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38462

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 38442

08/04/28 (1)

27.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

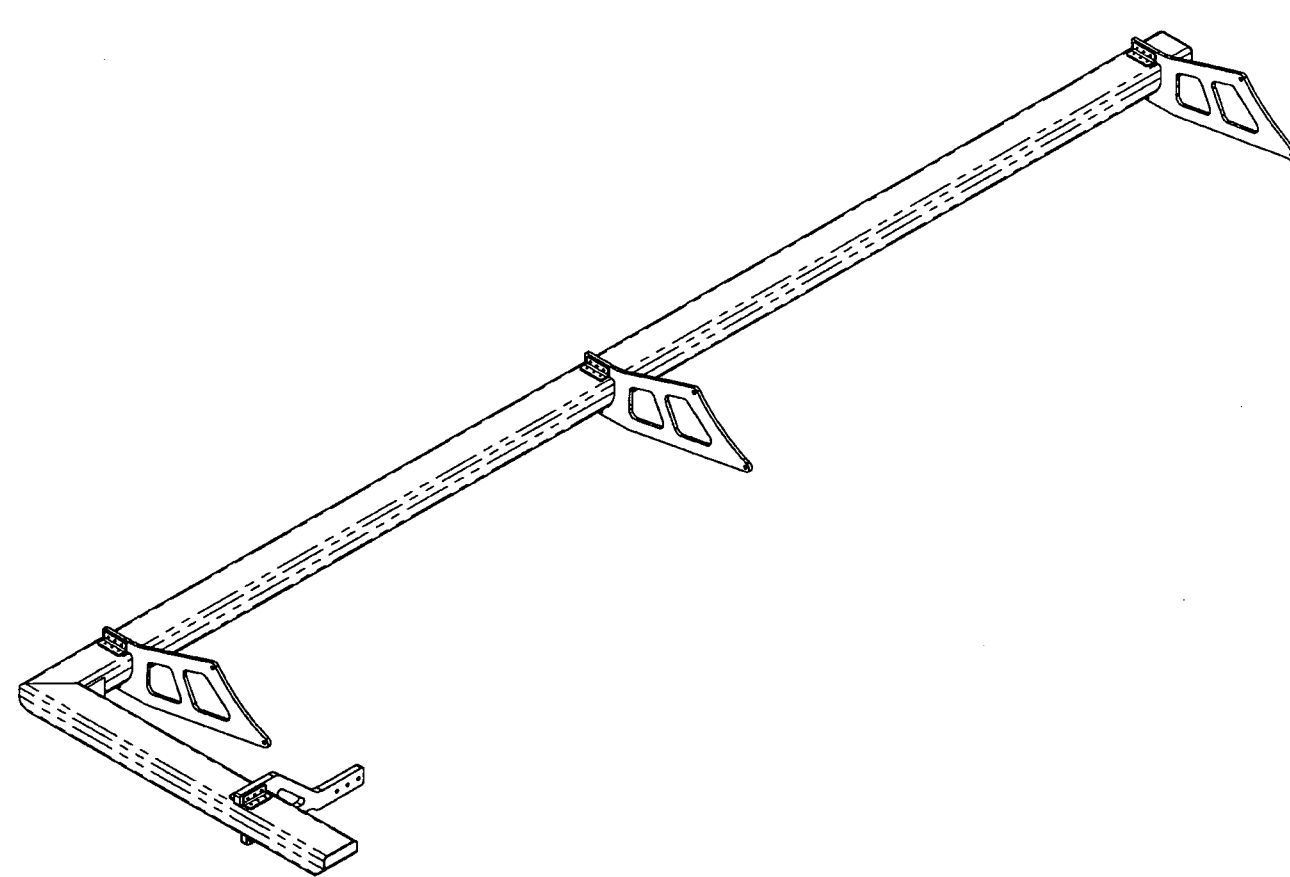
5

4


3

2

1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38462

D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE) 

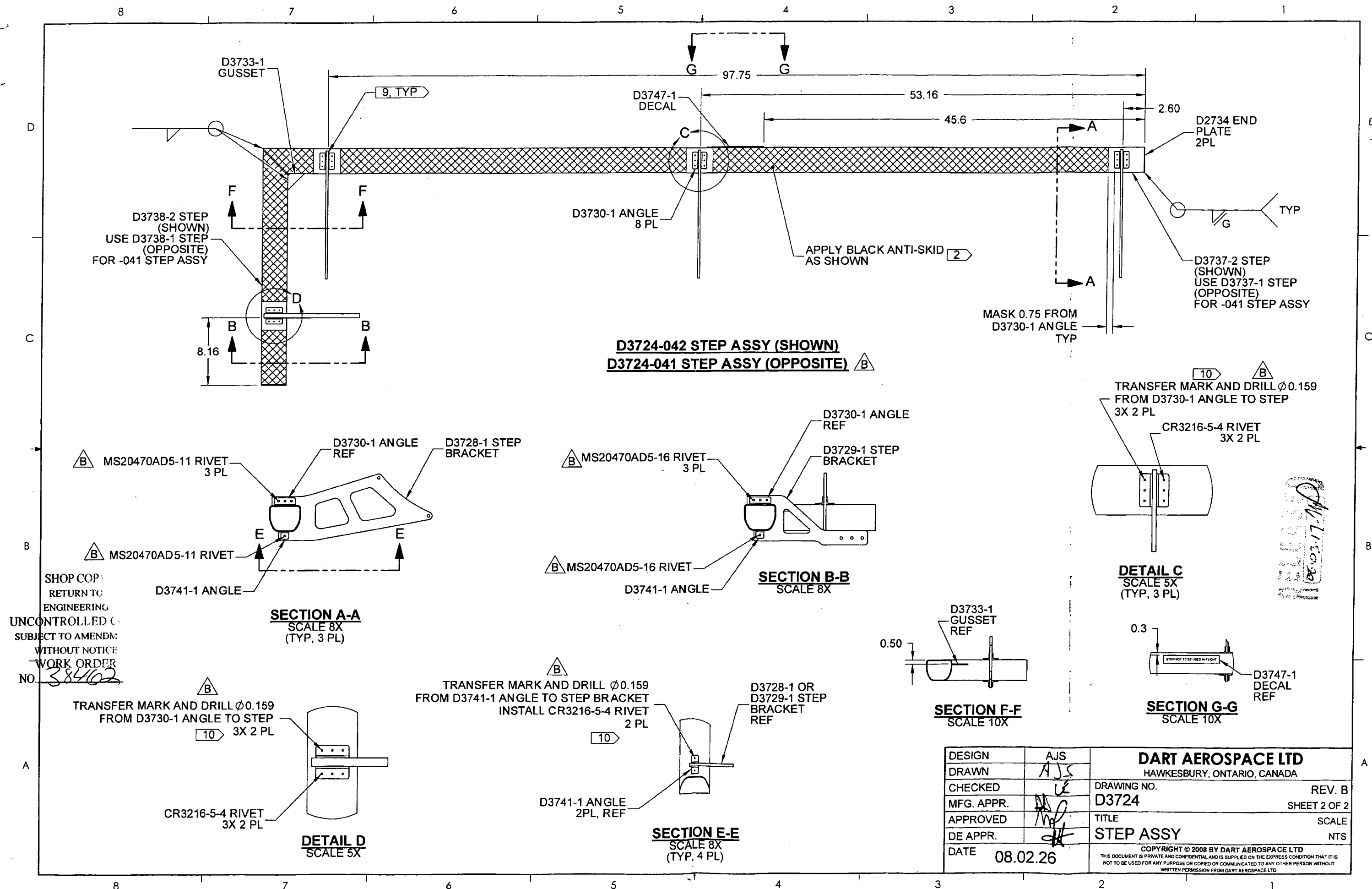
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.89 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
- 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

08-03-17/1P

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L. SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22, 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3724	SHEET 1 OF 2
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DE APPR.	MP	STEP ASSY	NTS
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